

Work Order ID. 58291

May 3, 2010 10:33:43 AM



Page 1

Item ID: D044-713-015

Accept



Setup Start



Revision ID:

Item Name: Passenger Door Window (Fits LH & RH)

Stop



Start Date: 03/05/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-5-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefiles & DT8721 Cutting Template and create labels per PPP
D044-713-015CHG001

S.10/06/18

for CL 10/06/18

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

= 7 m. 10/06/18

(2x)

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

S.10/06/18

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58291

May 3, 2010 10:33:43 AM



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Item ID: D044-713-015

Accept



Setup Start



Revision ID:

Item Name: Passenger Door Window (Fits LH & RH)

Stop



Start Date: 03/05/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D044-713-015								
	Location: <u>60</u>								
	PPP Rev: <u>A</u>								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

10-6-1851 (2x)

10/06/21 MF 10-6-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist-Print

May 3, 2010 10:33:48 AM

Page 1

Work Order ID: 58291

Parent Item: D044-713-015

Parent Item Name: Passenger Door Window (Fits LH & RH)

Comments: IPP Rev:A 05.03.22 New issue KJ/JLM

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

DT8721		Manufactured	No			110	Each	0.0000	1			
--------	--	--------------	----	--	--	-----	------	--------	---	--	--	--



template

D2126



Seal

Manufactured No

110 f

470.0884

6

2x m-k 10/06/18

P10

12 P10

Location

Loc Qty

Loc Code

ST405

470.0884211

48285

22.0884211

57106

448

12,000 m-k 10/06/18

D2977



Hinge Bracket

Manufactured No

110 Each

202.0000

1

Location

Loc Qty

Loc Code

ST032

202

14106

14

19560

188

2x m-k 10/06/18

D3279-1



Window

Manufactured No

110 Each

3.0000

1

Location

Loc Qty

Loc Code

st200

3

51691

3

2x m-k 10/06/18

MS21042-08



USE MS21042L08

Purchased No

110 Each

103.0000

1

Location

Loc Qty

Loc Code

ST301

103

103668

103

2x m-k 10/06/18

NI 114330

Dart Aerospace Ltd

W/O: 58291		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/6/16	100	perm. Jerry ADD length of seal (D21260720) to w/o detail	JD	10.06.21			S 10/6/18

Part No: D044-713-015 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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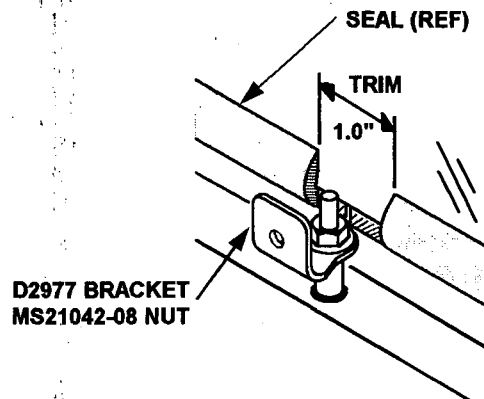


FIGURE 4 – D044-713-015 Passenger Door Window Kit – Tab Installation

4.0 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-713-011 Crew Door Window Kit	1.5 lb 0.68 kg	±24 in ±0.61 m	±36 in-lb ±0.43 m-kg	66 in 1.68 m	99 in-lb 1.1 m-kg
D044-713-013 Bubble Window Kit, LH	2.5 lb 1.1 kg	-28 in -0.71 m	-70 in-lb -0.78 m-kg	66 in 1.68 m	165 in-lb 1.8 m-kg
D044-713-014 Bubble Window Kit, RH	2.5 lb 1.1 kg	+28 in +0.71 m	+70 in-lb +0.78 m-kg	66 in 1.68 m	165 in-lb 1.8 m-kg
D044-713-015 Passenger Door Window Kit	1.2 lb 0.54 kg	±23 in ±0.58 m	±28 in-lb ±0.31 m-kg	83 in 2.11 m	100 in-lb 1.1 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Qty -014	Qty -015	Part Number	Description
X				D044-713-011	CREW DOOR WINDOW KIT, (FITS LH & RH)
	X			D044-713-013	BUBBLE WINDOW KIT, LH
		X		D044-713-014	BUBBLE WINDOW KIT, RH
			X	D044-713-015	PASSENGER DOOR WINDOW KIT, (FITS LH & RH)
			1	D2126-0720	SEAL
1	1	1		D2126-0903	SEAL
	1			D3269-1	BUBBLE WINDOW, LH
		1		D3269-2	BUBBLE WINDOW, RH
1				D3277-1	WINDOW
			1	D3279-1	WINDOW
	1	1		D3312-1	PLACARD
			1	D2977	BRACKET
			1	MS21042-08	NUT
*1	*1	*1		DT8720	D044-713-011/-013/-014 CUTTING TEMPLATE (FWD DOOR)
			*1	DT8721	D044-713-015 CUTTING TEMPLATE (AFT DOOR)

* Not to be installed. Cutting template only.

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